



Dart Aerospace Ltd.
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Canada

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D2721-041
Job Sheet 206264



LEFT

Part No: D2721-041

Job Qty: 4 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/20

Job Tracking No:

Due Date: 2/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Steps - 1	4 pcs			0.00	7.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	4			0.00	4.00	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
120	QC 9	4 pcs			0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		



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CANADA
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Container No: S252917



Part: D2721-041

Job No: 206264

Serial No/Batch: S252917

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/03/20

Plex 1/28/20 12:53 PM Dart.lajeunesse.marie

130 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	DAS
			QC 5 - 43	43
			QC 5 - 49	9-89
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	0.00 0.90	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	BEB20-02-06
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	

			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	DAS
			QC 7 - 43	43
			QC 7 - 61	9-89
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
160 Large Fab - Steps - 3 - B4B	4 pcs	0.00 7.60	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	DAS
			Large Fab - 6 - B4B	43
			Large Fab - 7 - B4B	9-89
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 10	4 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	Q
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	
180 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	CL
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
190 Handfinish - 1-2- Chemical- B4B	4 pcs	0.00 0.67	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	

			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	KL 20-2-10
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White GI(A)- B4B	4 pcs	0.00 0.88	Powdercoat - 1 - B4B	KL 20-2-10
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
210 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	BEB 20-02-14
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
220 Handfinish - 3-1- WingWalk- B4B	4 pcs	0.00 0.80	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	BEB 20-02-14
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
230 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	

			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	FEB 18 2020
			QC 3 - 19	DAS 40
			QC 3 - 43	9-89
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
240 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B	985
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

FEB 18 2020

985

FEB 18 2020

Part Op 100 - Fabricate per Drwg - Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A

- 110 - Large Fab - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10215A followed by Jig DT10215B A/R AL Rod Batch: _____ Grind end cap welds flush
- 120 - QC9- Inspect visual per QSI004- Fusion Welds
- 130 - QC5- Inspect part completeness to step on W/O
- 140 - Chemical Conversion Coat per QSI005 4.1
- 150 - QC7- Inspect Chemical Conversion Coat
- 160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: 4130137 Grind End Cap Welds Flush
- 170 - QC10- Inspect visual per QSI004- ground welds
- 180 - QC5- Inspect part completeness to step on W/O
- 190 - Chemical Conversion Coat per QSI005 4.1
- 200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: 1:10 pm OVEN TEMPERATURE: 375°F FINISH TIME: 1:25 pm
- 210 - QC3- Inspect Part Finish
- 220 - Wing Walk as per dwg QSI005 4.4 Batch _____
- 230 - QC3- Inspect Part Finish
- 240 - Identify as per dwg & Stock Location: _____
- 250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Steps - 1	<u>5243427</u> ✓
D2734	Step End Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>7225431</u> ✓
D3461-1	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>5072100</u> ✓
D3461-3	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>5072102</u> ✓
D3461-5	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>142353</u> ✓
D3461-7	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>5127723</u> ✓
MS20601-AD4W2	Rivet	4 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	<u>5228473</u> ✓
D2734	Step End Plate	4 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	<u>5242135</u> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	4	133	0
110-Large Fab - Steps - 2 - B4B	D2734	4	34	0
	D3461-1	4	9	0
	D3461-3	4	5	0
	D3461-5	4	19	0
	D3461-7	4	8	0
	MS20601-AD4W2	4	38	0
160-Large Fab - Steps - 3 - B4B	D2734	4	34	0

Part Specifications

Specifications could not be found.

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#1014317

Entered: _____ Date: _____



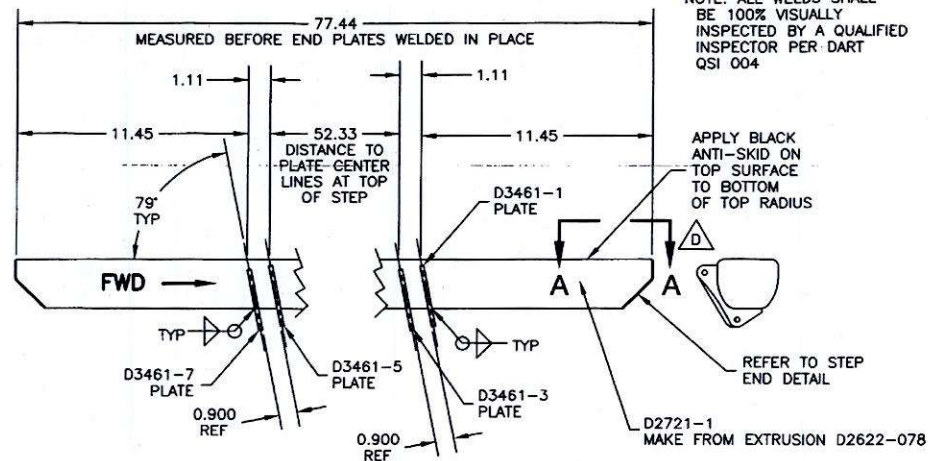
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

Qty -041	Qty -042	Part Number	Description
X	X	D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE
1	1	MS20601AD4W2	RIVET

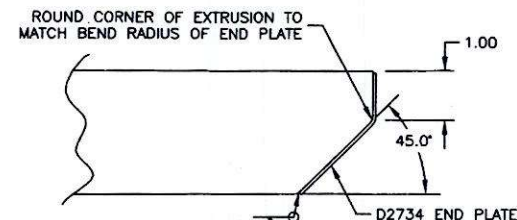


NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

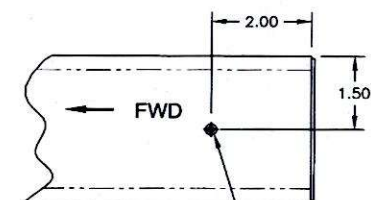
APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

REFER TO STEP END DETAIL

D2721-1 MAKE FROM EXTRUSION D2622-078



TYPICAL STEP END DETAIL
NOT TO SCALE



#0.129, CSK #0.225 x 100' OPTIONAL VENT HOLE FOR WELDING LOCATE ON THIS SURFACE PLUG WITH MS20601AD4W2 RIVET AFTER WELDING PRIOR TO FINISH

SECTION A-A
NOT TO SCALE

D2721-041 LH STEP ASSEMBLY (SHOWN) D2721-042 RH STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2721-041/-042" USING FINE POINT PERMANENT INK MARKER PER QSI 044 6.1
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

RELEASED
2016-08-02
ECN 16-620

D	ADD VENT HOLE REF. 14-355 (ZN C2-1) FORMATTED TO CURRENT STANDARD	RF	16.04.25
C	RE-DESIGN, ADD D3461-1/-3/-5/-7	PH	05.09.19
B	79° WAS 80°, UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0	KE	98.10.19
A	NEW ISSUE	KE	97.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. D
MFG. APPR.	DD	D2721	SHEET 1 OF 1
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	206B STEP ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	